

012588



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4812-041
Job Sheet 201304



Part No: D4812-041

Job Qty: 12 pcs **21**
9-89

Part Name: Patient Stop Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/23/19

Description:

Note: DWG REV B IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM IPP REV:B 16.04.19 AS PER DWG REV.B
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		10/23/19	0.17	3.18	Waterjet - Flow		JRB 6/12/19
110	QC 2	12 pcs		10/23/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S222134



Part: D4812-041

Job No: 201304

Serial No/Batch: S222134

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/12/19

9/30/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 8	12 pcs	10/23/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	JRB 10/12/19
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	OCT 15 2019 DAS 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - 2 - B4B	12 pcs	10/23/19	0.08 3.19	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	DAS 30 9-89
				Small Fab - 4 - B4B	OCT 22 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
140 QC 5	12 pcs	10/23/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	OCT 22 2019 DAS 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	

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150	Handfinish - 1-1 Chemical-B4B	12 pcs	10/23/19	0.00 1.39	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	★ OCT 23 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	QC 7	12 pcs	10/23/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	BK 10-10-23.
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	

					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
170	Powdercoat - 1 White Gl(A)- B4B	12 pcs	10/23/19	0.00 1.01	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
180	QC 3	12 pcs	10/23/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
190	Small Fab - 3 - B4B	12 pcs	10/23/19	0.00 3.19	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
200	QC 5	12 pcs	10/23/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	

OCT 24 2019 68

9-89

				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210	Packaging 3-1 - Stock - B4B	12	10/23/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
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					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 -
					Plex 9/30/19 3:20 PM Dart.lajeunesse.marie

PC ST 208

				B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	10/23/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	10/23/19
				QC 21 - SA - 53	10/23/19

Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)
 180 - (QC3- Inspect Part Finish)
 190 - (Small Fab)
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

OCT 2 5 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	24.3600 sf (2.03 ea)	100-Waterjet - Flow - 1	5190194
D2690-6	Lanyard	24 pcs (2 ea) ST009	190-Small Fab - 3 - B4B	20x 5 221895 - 4x 221895
D4811-1	Pin, Quick Release	24 pcs (2 ea) GA132	190-Small Fab - 3 - B4B	20x 5 221203 - 4x 221203
MS21042L3	Nut	24 Ea (2 ea) ST303	190-Small Fab - 3 - B4B	5211533
MS27039-1-07	Screw	24 Ea (2 ea) ST281	190-Small Fab - 3 - B4B	5193198
NAS1149D0332J	Washer	72 Ea (6 ea) ST264	190-Small Fab - 3 - B4B	5222100

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	24	366	0
190-Small Fab - 3 - B4B	D2690-6	24	56	0
	D4811-1	24	4	0
	MS21042L3	24	3,335	0
	MS27039-1-07	24	132	0
	NAS1149D0332J	72	1,624	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 201304
Description: Patient Stop		Part Number: D4812-041
Inspection Dwg: D4812 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0.192			WJ-01V	
Ø0.250	+0.005/-0.001	0.249			Tape	
Ø1.06	+0.012/-0.001	1.059				
7.50	+/-0.030	7.51				
8.94	+/-0.030	8.96				
9.13	+/-0.030	9.14				
1.00	+/-0.030	1.00				
3.50	+/-0.030	3.51				
12.50	+/-0.030	12.48				
0.50	+/-0.030	0.51				
10.00	+/-0.030	10.00				
8.00	+/-0.030	8.00				
0.94	+/-0.030	0.96				
2.00	+/-0.030	1.996				
4.00	+/-0.030	3.998				
2.50	+/-0.030	2.498				
2.50	+/-0.030	2.502				
4.00	+/-0.030	4.03				
0.771	+/-0.010	0.774				
1.763	+/-0.010	1.759				
4.750	+/-0.010	4.746				
32.0	+/-0.100	32.0				
5.00	+/-0.030	5.499				
1.00	+/-0.030	1.00				

DAS
40
9-89

Measured by: JRB	Checked by: DAS	QC Inspector:
Date: 10/12/19	Date: OCT 15 2019	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	
B	16.06.24	Dwg Rev updated	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QS1042)																																																																									
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition		Completed By																																																																									
Description Work Order Deviation				Lead hand / Supervisor																																																																													
Root Cause				QC / QA Coordinator																																																																													
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